

Date: Tuesday, 1/16/2007 11:07:05 AM
 User: Kim Johnston

Process Sheet

Split 07/03/08

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 1/4 TURN FASTNER RAIL (BLACK)
 Job Number : 30255
 Estimate Number : 10096
 P.O. Number : N/A Part Number : D103858B
 This Issue : 1/16/2007 S.O. No. : N/A Drawing Number : D1038
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
 Previous Run : 27878 Material : N/A
 Due Date : 1/30/2007 Qty: 80 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: E 03:05:02 Reformat; Added label KJ/RF
 Est Rev:F 06-08-16 Updated Packaging Procedures JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
 Create white labels and bag them

2.0 D2023 Extrusion, Fastener Rail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 Extrusion, Fastener Rail
 Batch: 321907

7mk 07/02/23 88

3.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

7mk 07/02/23 88

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio and Dwg D1038-58

J.F. Ank 07/02/24 88

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. Ank 07/02/24 88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:07:05 AM
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Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 30255

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/02/24 x 88

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

FF 07-02-27 88

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/02/27 88

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 3196
Black Anodize as per Dwg D1038

C 07/02/27 (88)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

07/02/27 (88) (88)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

ml 07/03/48
ml 07/03/07 x40
w/o split

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389

Batch: M 9050 X39
M 18727 X48


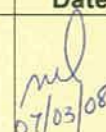



2-Grind wire flush and deburr

3-Clean

.049
PTO
ml 07/03/09 X47
ml 07/03/08 X40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/08	12	Scrap one Bar the edge was too much debris. The wire do not hold.	 08/04/08	Scrap and no replace	 07/03/08	 07/03/08	 08/04/08	 07/03/08

NOTE: Date & initial all entries

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Job Number: 30255

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA07/03/09

(47)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: _____

P-7/3/12

(41)

15.0

QC21

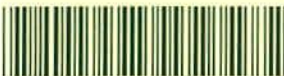
FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/13 (41)

Job Completion



07-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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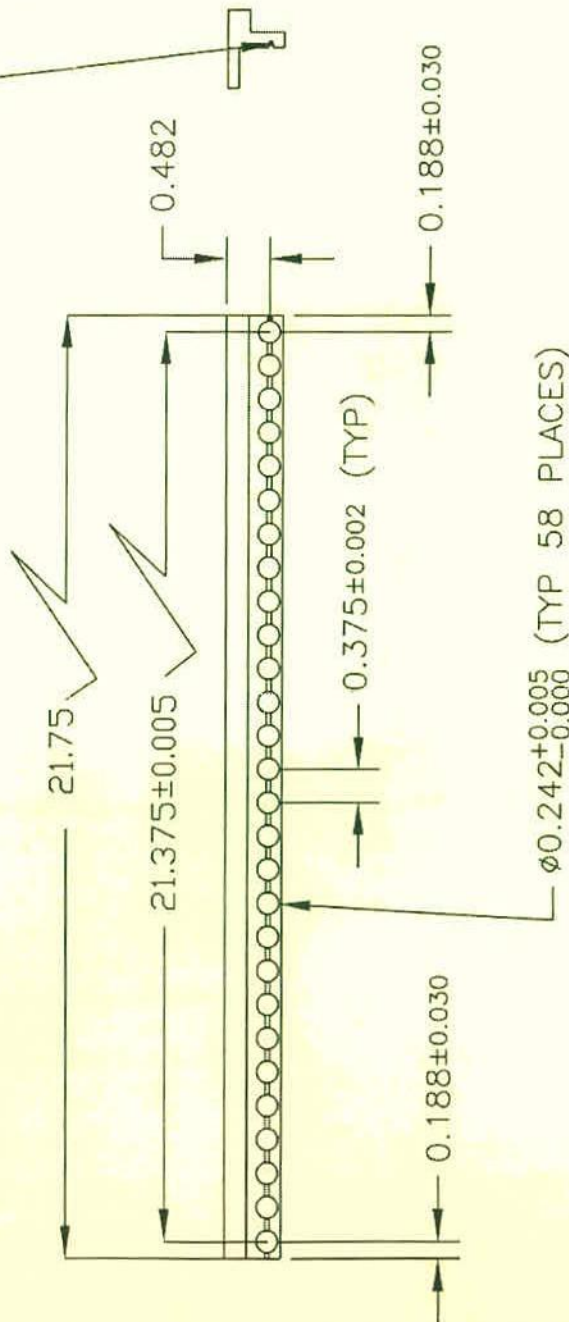
NOTE: Date & initial all entries

DART**RELEASED**

05.03.31

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02		TITLE 1/4 TURN FASTENER RAIL	SCALE NTS
-	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



- D1038-58 1/4 TURN FASTENER RAIL
- 1) MAKE FROM D2023 EXTRUSION
 - 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER
NO. 30255

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TNM

ANODISATION et PEINTURE TNM INC.

C. OF C



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / AS9100 certified
approuvé NADCAP approved

53482
05-Mar-2007

CLIENT / CUSTOMER:
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY, ONTARIO
K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 00003196



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	88	88	D103-858-B	B30255	MATL: AL BLACK ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

☐ Directeur de la Qualité / ☒ Manager ☐ ☐

TNM · ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

PACKING
SLIP

53482

05-Mar-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

PURCHASE ORDER/

NO. DE COMMANDE:

00003196

QTY	QUANTITY ORDERED	QTY	QUANTITY SHIPPED	PART NUMBER & DESCRIPTION	PART NUMBER & DESCRIPTION
1	88	88		D103-858-B	B30255

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la
valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts we are only liable for loss or damage to twice the invoiced finishing costs

